Work Order ID 118892 Tuesday, May 06, 2014 10:14:20 AM	*118	3892*			Page 1
Item ID: D3564-11 Revision ID: Item Name: Stainfess Steel Wearplate Aft Start Date: 5/21/14 Start Qty: 12.00 Required Date: 5/21/14 Req'd Qty: 12.00 Reference:	Accept *12* *12*	*N90004010 Cust Item ID: Customer:	ገ በ *	Setup Star Stop	
Approvals: Process Plan: <u>M</u> レブ	Date: <u>\\</u>	Date:	_	Run Star Stop	"INH I"
Sequence ID/ Operation Work Center ID Description	Set Up/ Run Hours	Tool ID Tool # Pla		t Reject Qty	Reject Insp. Number Stamp
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D3564 Rev D		1			
The second state of the s	0.00 0.00 wg D3564 *****(D3564-1F)*****Dwg Rev:_ 2-Deburr if necessary	D Prog	_(3	0	Jm14-05+
110 QC2- Inspect parts off mac	hine FAI/FAIB 0.00				
110 QC Quelity Control	0.00		_13		Jm14-05-1
120 QC8- Inspect parts - secon *120 * QC8- Inspect parts - secon Memo Quality Control	d check 0.00 27 9-89	.50	13		

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						WORK ORDER NON	-C(ONFO	RMANCE / L	JPDATE					AEROSPACE
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Part N	VO.				 8	Scrap			Machining	Small Fab		4	d. Eng. Coor.	-	Quality
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INCKI	VO.				- .e	Suspected Unapproved	J		Large Fab	Composite		J	Supplier	_	
Root					Desc	ription of work order update		Initial	Ac	tion		Sign &			
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		Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorrec	i.		Temperature/Cure
		Crimp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/U	Inqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		-	ions Incomplete/			Part Moved			Wrong Stock Pulled
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		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence						

Work	Order	·ID	118892
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Page 2 Tuesday, May 06, 2014 10:14:21 AM Item ID: D3564-11 Accept *N900040100* Setup Start Revision ID: Item Name: Stainless Steel Wearplate Aft Start Date: 5/21/14 Start Qty: 12.00 Cust Item ID: Required Date: 5/21/14 Req'd Qty: 12.00 Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Oty Qty Number Stamp 130 0.00 NC BRAKE *130* DAS Brake NC 30 Memo 0.00 9-89 Brake AC Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT8179 140 QC5- Inspect part completeness to step on W/O 0.00 *140* Memo Quality Control 150 0.00 *150* Large Fab Large Fab Memo 0.00 Large Fab Description BatchA/R 2059B Hardcoat m 127980 Weld hardcoat as per Dwg D3437

DQA:			Date:											1	DART
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QA Closed:			Date:						Ξ.		Wo	ork Order up	date only		
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					_	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1	j	Machining	Small Fab		Pro	d. Eng. Coor.	\neg	Quality
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NCR N	10.				_	Suspected Unapproved]		Large Fab	Composite			Supplier[
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	\exists	Centre No	ot Concer	ntric		BOM/Route		Grain			-	Over/Under	necostate certains e	_	et-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	i l	Т	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	V	Veld
		Cuffs	150 100			Contamination		200	tions Incomplete/I		-	Part Moved		V	Vrong Stock Pulled
		Crushing				Countersink		-1	ned/off center			Positioned V	Vrong		
		Heat Trea	it			Cut Too Short		Mislabe	eled			Power Loss/	Surge [C	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d						
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
1		Mayo/Tw	ist in Tub	10		Fit/Function		Out of	Saguence						

Work Order ID 118892

Tuesday, May 96, 2014 10:14:21 AM

118892

Page 3

Item ID: D3564-11 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Stainless Steel Wearplate Aft Start Date: 5/21/14 Start Otv: 12.00 *12* Cust Item ID: Required Date: 5/21/14 Reg'd Oty: 12.00 *10* Customer: Reference: Start Run Process Plan: Approvals: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 160 QC10- Inspect visual per QS1004- ground welds 0.00 *160* 14-06-02 D OC. 0.00 Memo Quality Control 170 QC5- Inspect part completeness to step on W/O 0.00 *170* 14.0602 0.00 Memo Quality Control 180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 NI 12500 *180* Powdercoat Memo Powder Coating OVER TEMPERATURE: FINISH TIME

DQA:		Date:												TOAC
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPD	ATE				_	AEROSPACE
QA Closed:		Date:								W	ork Order up	odate only		
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	3110				Rework			Skid-tube	Crosstube			Water Jet	Eng	gineering
Part N	lo.				Scrap		1	Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	lo			g	Suspected Unapproved			Large Fab (Composite			Supplier		
Root				Descr	ription of work order update	-	nitial	Action	1		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	ion		Date	Verification	C	C Inspector
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Landir	ng Gear				General		i -				1		_	Marcel 65
	Bending				Bend			rogram			Outside Dim			ure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain				Over/Under	_	Set-u	
8.4	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	-	_	erature/Cure
	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqu	alified		Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		1	ions Incomplete/Unc	lear		Part Moved	L	Wron	ig Stock Pulled
	Crushing				Countersink		1	ned/off center			Positioned V		_	
	Heat Trea				Cut Too Short		Mislabe				Power Loss/	Surge	Other	r
	Inspectio		Tube		Drawing		Misread	d						
	Marks/Ch	natter			Drill Holes		Off-set				j.			
	Turning S				Finish		-	Calibration						
	Wave/Tw	ist in Tul	oe		Fit/Function		Out of S	Sequence						

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Page 4

Tuesday, May 96, 2014 10:14:21 AM Item ID: D3564-11 Accept *N900040100* Setup Start Revision ID: Stop Stainless Steel Wearplate Aft Item Name: Start Date: 5/21/14 Start Qty: 12.00 *12* Cust Item ID: Required Date: 5/21/14 Req'd Qty: 12.00 *12* Customer: Reference: Start Run Process Plan: Approvals: Tooling: Date: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool# Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp DAS 190 QC3- Inspect Part Finish 0.00 27 *190* OC Memo Quarity Control Identify as per dwg & Stock Location: FP-007 200 *200* Packaging 0.00 Memo Packaging 210 QC21- Final Inspection - Work Order Release 0.00 *210* OC: 0.00 Memo Quality Control

Mrs 140603

o		Date:			WORK ORDER NON-	-cc	ONFOR	RMANCE / U		ork Order up	date only	AEROSPACE
0		Date:			DISPOSITION	_		LX.	W	ork Order up	date only	
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0					1,44000 - 101,000,000				AGAINST DE	PARTMENT	PROCESS	
					Rework Scrap Use-as-is Suspected Unapproved		Therm		Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
T				Desc	rintion of work order undate		nitial	Δς	tion	Sign &		
	Date	Step	Otv	Desc	O					100	Verification	QC Inspector
						FAL	JLT CAT	EGORY				
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	g G	Date Gear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning Se	Date Step Gear Bending Centre Not Concent Cracks Crimp/Kink/Ripple, Cuffs Crushing Heat Treat Inspection Strip in Marks/Chatter Turning Sequence	Date Step Qty Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence	Date Step Qty Description of work order update or non-conformance g Gear General Bending Bend Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Cuffs Contamination Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Step Qty Description of work order update or non-conformance General Bend BoM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	Date Step Qty Description of work order update or non-conformance Character Step Qty Or non-conformance Char	Suspected Unapproved Date Step Qty Description of work order update or non-conformance Chief Eng FAULT CAT General Bending Bend Folio/P Centre Not Concentric BOM/Route Grain Cracks Broken/Damage/Defect Hardwa Crimp/Kink/Ripple/Wave Burrs Inspectic Cuffs Contamination Instruct Crushing Countersink Misalig Heat Treat Cut Too Short Mislabe Inspection Strip in Tube Drawing Marks/Chatter Turning Sequence Finish Out of Co	Date Step Qty Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description Operation Description Operation Description Operation Description Operation Description Operation Op	Suspected Unapproved Date Step Qty Description of work order update or non-conformance FAULT CATEGORY Gear General Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Custing Countersink Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Marks/Chatter Drill Holes Out of Calibration Count of Calibration	Suspected Unapproved Large Fab Composite Date Step Qty Description of work order update or non-conformance Chief Eng Description Date FAULT CATEGORY General Bending General Bending General Bend Grain Gover/Under Grain Grain Grain Gover/Under Grain	Suspected Unapproved Large Fab Composite Supplier Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification

Page 1

Work Order ID: 118892

118892

Parent Item:

D3564-11

D3564-11

Parent Item Name:

Stainless Steel Wearplate Aft

Start Date: 5/21/14

Required Date: 5/21/14

Start Qty: 12.00

Loc Code

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D

Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304516GA		Purchased	No			100	sf	80.5670	1.41	18			
M304S16	GA								**			T	m 111-0

304/316 Sheet .063

Location Loc Oty MAT020 80.567

> M127821 80.567

129192

129192

DQA:			Date:												TAADT
						WORK ORDER NON	-CO	ONFO	RMANCE / U	JPDATE					AEROSPACE
QA Closed:			Date:						25		Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
Part N						Rework Scrap		,	Skid-tube Machining	Crosstube Small Fab	-	Pro	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	-	Rec/Stor	e/Packaging Supplier	-	Other
Root					Desc	ription of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Landir	ng G	iear				General									
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	-	Crimp/Kin	k/Ripple	/Wave		Burrs		CONTRACTOR CONTRACTOR	ion Incomplete/U	Inqualified	-	Part Lost/Mi			Weld
	-	Cuffs				Contamination		100	ions Incomplete/		-	Part Moved	199	Г	Wrong Stock Pulled
	\neg	Crushing				Countersink		1	ned/off center		-	Positioned W		_	
	\neg	Heat Trea	t			Cut Too Short		Mislabe			-	Power Loss/S			Other
		Inspection	Strip in	Tube		Drawing		Misread	i		_		- Indire-		
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning Se	equence			Finish		Out of (Calibration		,				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence		,				

	Work Order:	11 889/
DART AEROSPACE LTD	WOIR Cider.	110010
	Part Number:	D3564-11
Description: Wearshoe		
Inspection Dwg: D3564 Rev: D		Page 1 of 1

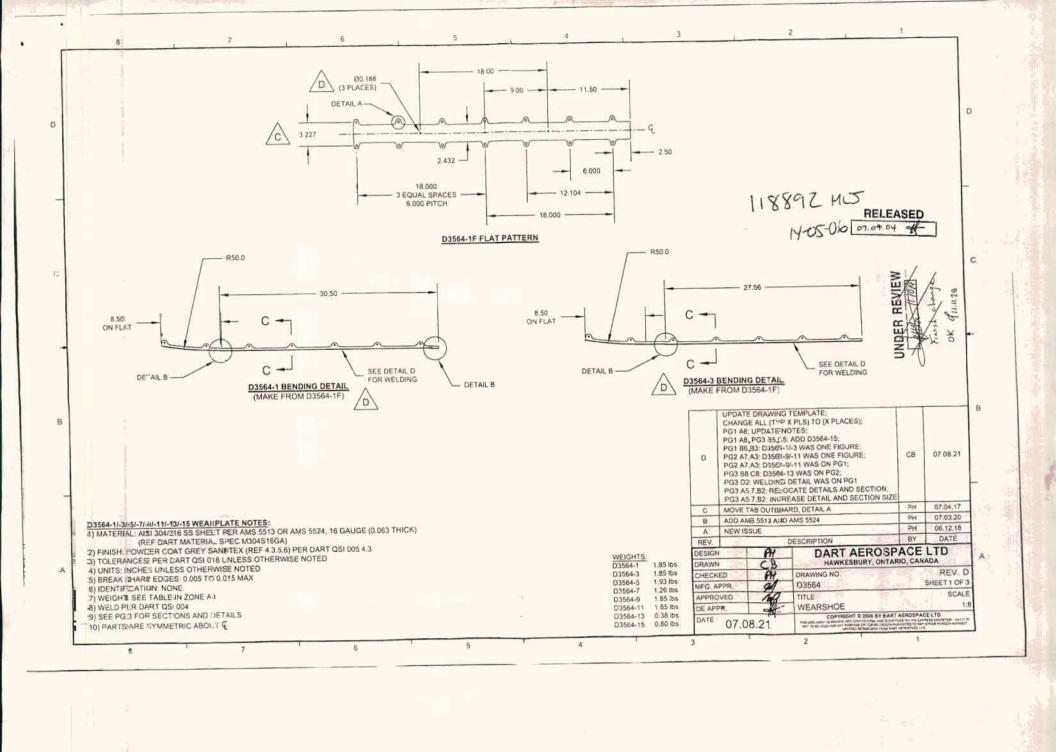
FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension	+/-0.010	3 231	_		V	J)mos
3.227	+/-0.010	2,436	-		V	
2.432	+/-0.030	2.50	-		V	
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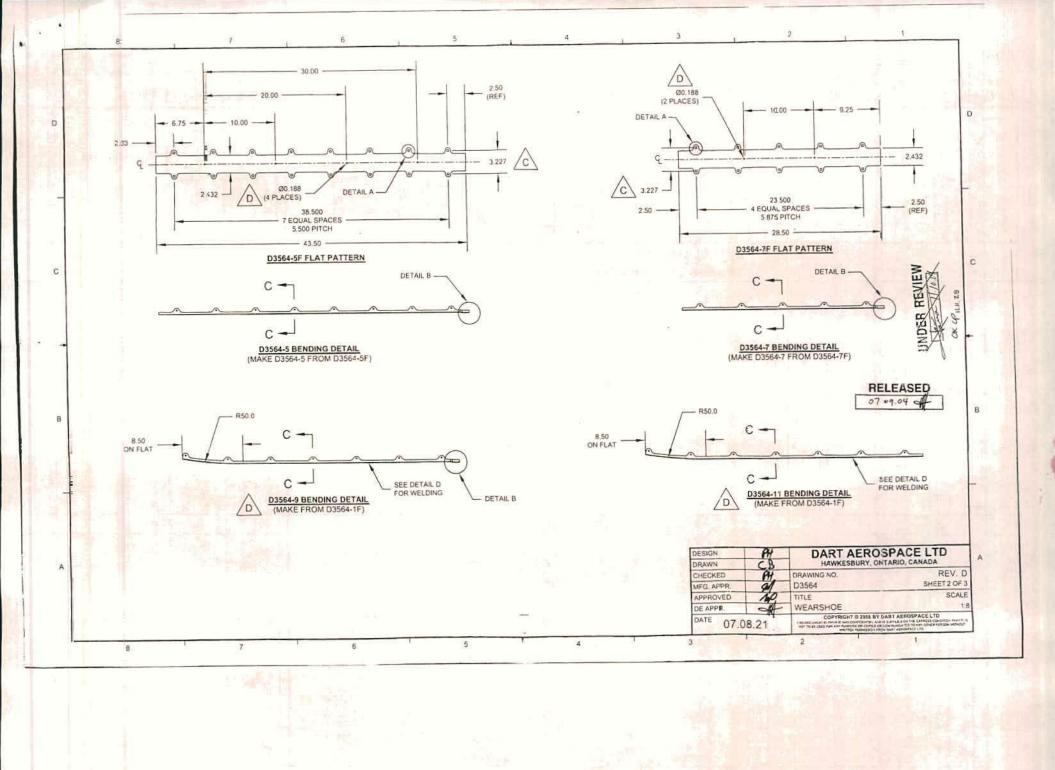
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Measured by:	Jm		11/6/24	Date:	N/A
Date:	14-05-16	Date:	1417190	Dute:	

		1080 10	Revised by	Approved
Rev	Date	Change	KJ/JLM	17.
A	07.09.06	New Issue	KJ/EC/DD	1/7
В	07.11.23	Dwg Rev updated	THE STATE OF THE S	100

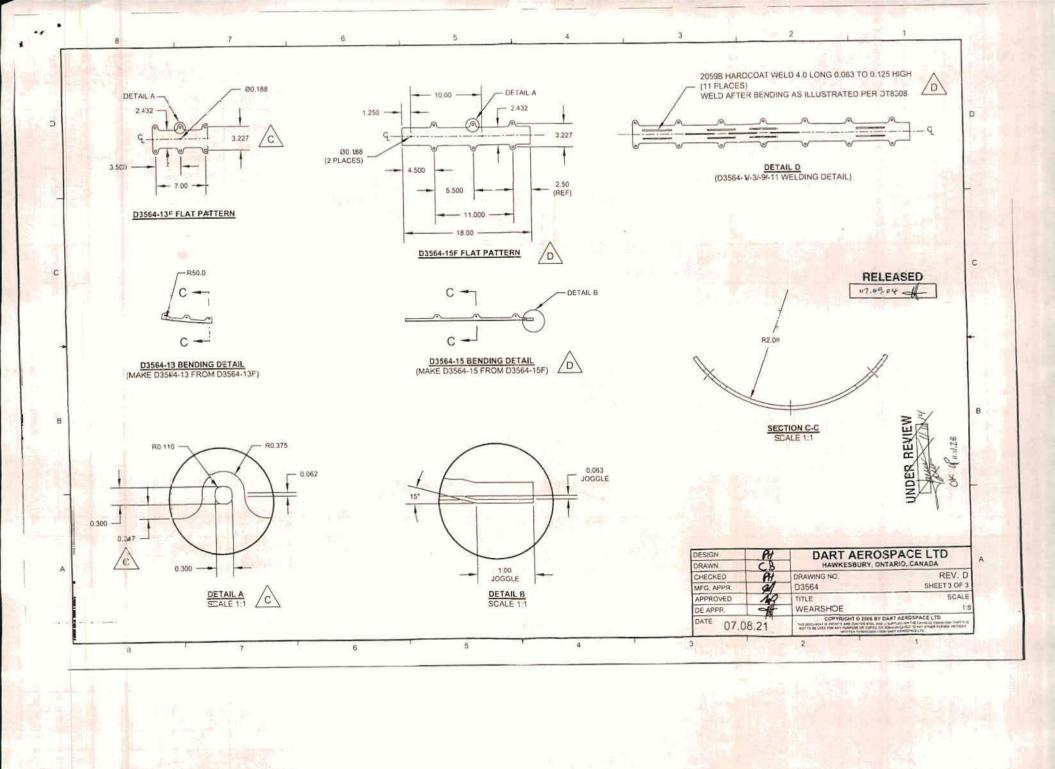
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						Use-as-is		Thern	noforming Finishing	g Finishing Rec/Store/Packagin				Other
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- 12	-	Cuffs	ny mppie,	, avave		Contamination	\vdash	Instructions Incomplete/Unclear			Part Moved			Wrong Stock Pulled
	\vdash	Crushing				Countersink		-	gned/off center	\vdash	Positioned V	l √rong		Wilding Stock anda
	-	Heat Trea	t		-	Cut Too Short	_	Mislabe						Other
	-	Inspection		Tube		Drawing		Misread		cost surge				
	-	Marks/Ch				Drill Holes		Off-set						
	-	Turning S				Finish		-	Calibration					
	Wave/Twist in Tube					Fit/Function		-	Sequence					



DQA:			Date:												DART
						WORK ORDER NON	-C(ONFO	RMANCE / U	IPDATE					AEROSPACE
QA Closed:			Date:						5		Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
transport Statements						Rework	Rework			Skid-tube Crosstube					Engineering
Part N	lo.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is			noforming	Finishing		Rec/Stor	re/Packaging	Other		
NCR No.				Suspected Unapproved			Large Fab	Composite							
Root					Desc	ription of work order update		I Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	2000	or non-conformance		nief Eng		cription		Date	Verificatio	n	QC Inspector
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		Bending				Bend		Folio/P	Folio/Program			Outside Dimensions			Pressure/Forced
		Centre Not Concentric				BOM/Route		Grain	Grain			Over/Under tolerance			Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorrect			Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		Inspecti	tion Incomplete/Unqualified			Part Lost/Missing			Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	plete/Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned Wrong				
		Heat Treat				Cut Too Short		Mislabe	eled			Power Loss/Surge			Other
	Inspection Strip in Tube			Tube		Drawing		Misread	i i						
		Marks/Ch				Drill Holes		Off-set						_	
		Turning S				Finish		Out of 0	Calibration					_	
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence						



DQA: Date:	DART
WORK ORDER NON-CONFORMANCE / UPDATE	AEROSPACE
QA Closed: Date: Work Order update only	
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	
Rework Skid-tube Crosstube Water Jet	Engineering
Part No. Scrap Machining Small Fab Prod. Eng. Coor.	Quality
Use-as-is Thermoforming Finishing Rec/Store/Packaging	Other
NCR No Suspected Unapproved Large Fab Composite Supplier	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification	QC Inspector
Design	
Doc/Data	
Equip/Tooling	
Handling/Pre	
Material	
Operator	
Offset/Setup	
Process	
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FAULT CATEGORY	
Landing Gear General	
Bending Bend Folio/Program Outside Dimensions	Pressure/Forced
Centre Not Concentric BOM/Route Grain Over/Under tolerance	Set-up
Cracks Broken/Damage/Defect Hardware Part Incorrect Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing	Temperature/Cure Weld
	Wrong Stock Pulled
Cuffs Contamination Instructions Incomplete/Unclear Part Moved Crushing Countersink Misaligned/off center Positioned Wrong	Wiong Stock Fulled
Heat Treat Cut Too Short Mislabeled Power Loss/Surge	Other
Inspection Strip in Tube Drawing Misread	Julies
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	



DQA:		_ Date:				_								DART	
QA Closed:	12	Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE	14/	ork Order u	ndate only	_	AEROSPACE	
LA CIOSEU.		Date.				_				VV	ork Order up	date only			
Work Order:					DISPOSITION										
					Rework		Skid-tube		1	Water Jet	Engineering				
Part N	0.				Scrap		8	Skid-tube Crosstube Machining Small Fab			Prod. Eng. Coor.			Quality	
				_	Use-as-is		279.121.11	noforming Finishing			Rec/Store/Packaging			Other	
NCR N	0				Suspected Unapproved			Large Fab	Composite			Supplier			
		_									T				
Root	250	020	2000	Desci	ription of work order update		Initial	100	tion		Sign &	2003 1996 50		7525/92010F1 24	
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verificatio	n	QC Inspector	
Design	_														
Doc/Data															
Equip/Tooling	_														
Handling/Pre												784			
Material															
Operator															
Offset/Setup															
Process		1													
Supplier															
Training	Ц														
Transport															
Unapproved															
						FA	ULT CAT	EGORY							
Landir	g Gear				General	_					-		_		
	Bending				Bend		Folio/P	/Program			Outside Dimensions			Pressure/Forced	
	Centre Not Concentric Cracks				BOM/Route		Grain				Over/Under	tolerance		Set-up	
					Broken/Damage/Defect		Hardwa	re			Part Incorred	ા		Temperature/Cure	
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified			Part Lost/Missing			Weld	
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear			Part Moved		L	Wrong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong	_		
	Heat Treat				Cut Too Short		Mislabe	led			Power Loss/Surge			Other	
	Inspection Strip in Tube				Drawing		Misread	1							
	Marks/0	Chatter			Drill Holes		Off-set								
	Turning	Sequence			Finish		Out of 0	Calibration							
	Wave/T	wist in Tub	oe		Fit/Function		Out of S	Sequence			CI CI				